

**\*83076\***

Page 1

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**\*4\***

**Cust Item ID:**

**\*4\***

**Customer:**

**Reference:**

Process Plan: ML5

Date: 12/04/13

### Tooling:

Date:~

Run Start \*NR1\*

**"QC:**

Date:

**SPC (Y/N):**

**Date:**

Stop \*NR2\*

**Insp.**  
**Stamp**

Revision Nbr

D2037

D

0.00

**\*100\***

NC BRAKE

0.00

Brake NC

## Memo

Brake NC

Punch as per Dwg D2037. Keep hole distance 45.50" using Jig D2037-101T1

110

0.00

**\*110\***

## Small Fab

0.00

Small Fab

## Memo

## Small Fab

1-Drill Ø0.323" holes in D2037-101 tube as per Dwg D2037  
ends of D2037-101 tube as required using DT8545  
3-Deburr as required

120

QC5- Inspect part completeness to step on W/O

0.00

**\*120\***

QC

## Memo

0.00

## Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 83076

\*83076\*

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April-12-12 4:09:27 PM

Item ID: D2037-101 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Arm  
 Start Date: 12/04/2012 Start Qty: 4.00 \*4\* Cust Item ID:  
 Required Date: 26/04/2012 Req'd Qty: 4.00 \*4\* Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location <u>WA</u>	0.00							
*130*									
Packaging	Memo	0.00				6		545 12/5/23	
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
*140*									
QC	Memo	0.00							12/5/23
Quality Control									

MWJ 12/05/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

April-12-12 4:09:31 PM

Page 1

Work Order ID: 83076

**\*83076\***

Parent Item: D2037-101

**\*D2037-101\***

Parent Item Name: Arm

Start Date: 12/04/2012

Required Date: 26/04/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 05-11-01 JLM  
IPP Rev:B 08-07-29 revD as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304TR0.750W.049

Purchased

No

110

f

306.2570

3.916

16.48842

\*\*

Sp 12/05/12

**\*M304TR0 750W 049\***

304 RD Tube .750 x .049W

Location

Loc Qty

Loc Code

MAT017

306.257

109314

9.333

111619

3

112187

4

112800

11

114852

2.75

116108

3

117797

0.75

120441

37.534

121170

234.89

121666

18

+4

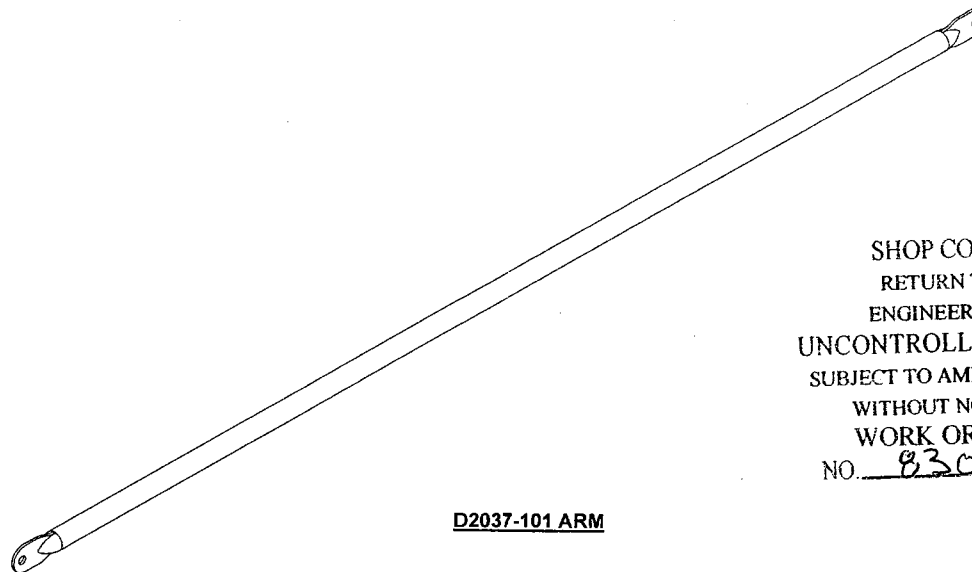
W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries



**D2037-101 ARM**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 83076 MLW  
12/04/13

REL 150  
68 07 07 140

**NOTES:**

- 1) MATERIAL: AISI 304/316, STAINLESS STEEL ROUND TUBE,  $\varnothing 0.750 \times 0.049$  WALL  
REF. DART SPEC M304TR0.750W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.50 lbs
- 8) FOR FURTHER INFO SEE DRAWING D2638.

D	INCORPORATED C1, C2 & C3. REDRAWN TO SOLIDWORKS FORMAT WITH CURRENT STANDARDS. ORIGINAL "SQUARE END" CONFIGURATION DELETED (SEE REV. C FOR FURTHER DETAILS). SHEET 2 DETAIL A NOW INDICATED AS 2 PL. REASON FOR CHANGE: QC/PRODUCTION REQUEST.	AJS	08.05.08
C	REDRAWN, 0.386 WAS 0.375.	RF	99.06.07
B	-103 DELETED	JB	93.04.20
A	NEW ISSUE	JB	91.10.22
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	JB	DRAWING NO.	REV. D
MFG. APPR.	JB	D2037	SHEET 1 OF 2
APPROVED	JB	TITLE	SCALE
DE APPR.	JB	ARM	NTS
DATE	08.05.08	<small>COPYRIGHT © 1991 BY DART AEROSPACE LTD  THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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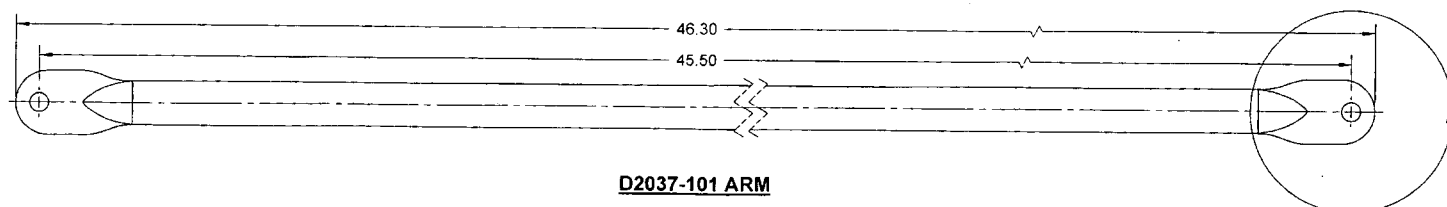
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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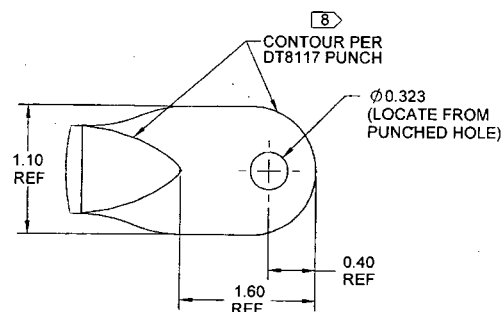
**NOTE:** Date & initial all entries



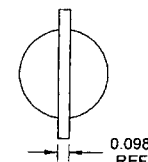
83076



**D2037-101 ARM**



**DETAIL A**  
SCALE 2X  
2 PL



RELEASED  
08.07.07

DESIGN	JB	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D2037	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		ARM	NTS
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